

ORIGINAL

Application Based on

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Customer No. 01333

**SLIPPING LAYER FOR DYE-DONOR ELEMENT USED IN
THERMAL DYE TRANSFER**

MAIL STOP PATENT APPLICATION

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SLIPPING LAYER CONTAINING WAX MIXTURE FOR DYE-DONOR ELEMENT USED IN THERMAL DYE TRANSFER

CROSS REFERENCE TO RELATED APPLICATION

5 Reference is made to commonly assigned, co-pending U.S. Patent Applications Serial Number:_____ by Foster et al., filed of even date herewith (Docket 86697), entitled "Slipping Layer For Dye-Donor Element used in Thermal Dye Transfer" and Serial Number:_____ by Foster et al., filed of even date herewith (Docket 86698), entitled "Slipping Layer Containing Branched Olefin For
10 Dye-Donor Element used in Thermal Dye Transfer."

FIELD OF THE INVENTION

 This invention relates to dye donor elements used in thermal dye transfer, and more particularly to the use of a blend of waxes, including an alpha-olefin maleic anhydride polymer or the like, in the slipping layer on the back side thereof to
15 improve the performance of the donor element before and during the printing operation.

BACKGROUND OF THE INVENTION

 In recent years, thermal transfer systems have been developed to obtain prints from pictures which have been generated electronically from a color camera.
20 According to one way of obtaining such prints, an electronic picture is first subjected to color separation by color filters. The respective color-separated images are then converted into electrical signals. These signals are then operated on to produce cyan, magenta and yellow electrical signals. These signals are then transmitted to a thermal printer. To obtain the print, a cyan, magenta or yellow dye-donor element is placed
25 face-to-face with a dye-receiving element. The two are then inserted between a thermal printing head and a platen roller. A line-type thermal printing head is used to apply heat from the back of the dye-donor sheet. The thermal printing head has many heating elements and is heated up sequentially in response to the cyan, magenta and yellow signals. The process is then repeated for the other two colors. A color hard
30 copy is thus obtained which corresponds to the original picture viewed on a screen. Further details of this process and an apparatus for carrying it out are contained in U.S.

Patent No. 4,621,271 by Brownstein entitled "Apparatus and Method for Controlling A Thermal Printer Apparatus," issued November 4, 1986, the disclosure of which is hereby incorporated by reference.

U.S. Patent 4,910,087 discloses a heat-resistant slipping layer on the back surface of a thermal dye-donor element comprising a polyurethane or polyurea resin modified with polysiloxane bonds. There are a number of problems with this slipping layer including sticking between the dye layer and slipping layer when the donor is rolled up and head debris built-up upon processing. It is an object of this invention to eliminate or reduce such problems.

US Patent 5,627,130 discloses a heat-resistant slipping layer on the back surface of a thermal dye-donor element comprising a siloxane copolymer for a dye-donor slipping layer. US Patent 4,916,112 discloses a slipping layer comprising a nonhomogenous layer of a particulate ester wax.

US 4,898,751 to Dwivedy discloses methods and compositions for inhibiting and/or preventing the adhesion of materials such as coal or coke to container walls due to weather conditions. The composition comprises a polymeric poly- α -olefin wax and a resin in a hydrocarbon solvent.

US Patent No. 5,939,207 to Fensore et al. discloses a dye-donor element including a release layer between a pigmented layer and a substrate, the release layer composed of an ethylene vinylacetate copolymer, an α -olefin maleic anhydride copolymer and a wax. EP 1205 313 A1 to Eike discloses a dye-donor element with a coloring layer on a substrate wherein the coloring layer is formed of a mixture of a copolymerization product obtainable by polymerizing an α -olefin/a maleic acid anhydride copolymer with a maleic acid anhydride monoester and an ethylene/vinyl acetate copolymer. Finally, US Patent Publ. 2002/0044192 to Hirano discloses a similar composition used as an adhesive layer disclosed between a coloring layer and a substrate of a dye-donor element, also referred to as a thermal transfer sheet.

A continuing problem with dye-donor elements in the prior art, especially when enabling faster printing, is sticking or friction between the dye-donor element and the thermal head, undesirable folds, and retransfer.

In particular, a problem arises with the use of dye-donor elements for fast thermal dye-transfer printing because a thin support is required in order to provide effective heat transfer. For example, when a thin polyester film is employed, it can soften when heated during the printing operation and then sticks to the thermal printing head, preventing donor transport. A slipping layer is typically provided to facilitate passage of the dye-donor under the thermal printing head. A deficiency in the performance of that layer causes intermittent rather than continuous transport across the thermal head. The dye transferred thus does not appear as a uniform area, but rather as a series of alternating light and dark bands (so-called "chatter marks").

A desirable performance characteristic for a slipping layer is a smooth transfer across a wide range of printing conditions. Variable print forces along either the length or width of a print could cause image defects. Differences in print forces are specially magnified in regions of abrupt temperature change. At the transition from D_{max} ((maximum print density) to D_{min} (minimum print density), the force may spike upward from D_{max} to a peak force and then return to D_{min} . This differential is referred to as "pops" since an audible popping noise can be heard in extreme cases during printing.

SUMMARY OF INVENTION

This invention relates to a dye-donor element for thermal dye transfer comprising a support having on one side thereof a dye layer and on the other side a slipping layer comprising a lubricating material and wherein the lubricating material comprises a solid polymer derived from a polyolefin and an ethylenically unsaturated carboxylic acid or ester or anhydride thereof; and at least one wax.

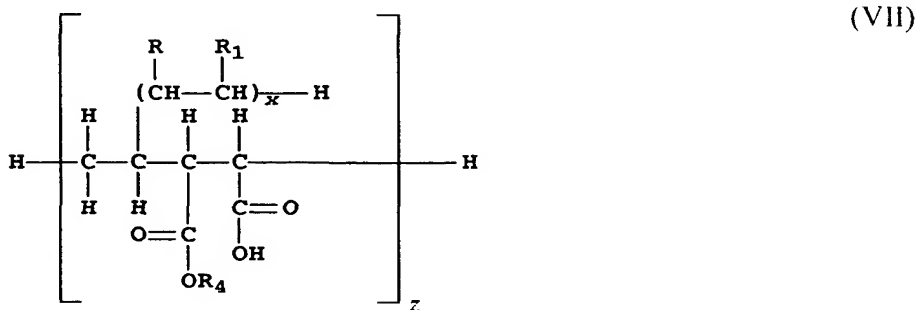
In particular, the invention relates to a new slipping layer formulation for resistive head thermal media which incorporates a synergistic combination of lubricants from a friction perspective and in terms of headwear buildup. Additional benefits include preventing or reducing folds, especially when used with relatively fast printers, for example at 4 milliseconds per line. A still further benefit is the prevention of retransfer of dye from the dye donor during production. Finally, the slip layer is capable of being coated at high speed.

DETAILED DESCRIPTION OF THE INVENTION

As indicated above, the invention is directed to a dye-donor element for thermal dye transfer comprising a support having on one side thereof a dye layer and on the other side a slipping layer comprising a wax mixture, the improvement wherein said wax mixture comprises a solid polymer derived from a polyolefin and an ethylenically unsaturated carboxylic acid or ester or anhydride thereof; and at least one other wax. Suitable polymers include those set forth in U.S. Pat. No. 3,590,076, herein incorporated by reference in its entirety. The number average molecular weight of the polymer is generally from about 300 to about 5000.

The polyolefin is preferably derived from an α -olefin, preferably one containing between about two to about eight carbon atoms. Ethylene and/or propylene are especially preferred. Suitable ethylenically unsaturated carboxylic acids are those having between about 3 to about 12 carbon atoms, preferably 4 to 5 carbon atoms. Dicarboxylic acids and anhydrides thereof are preferred. These include maleic acid, ethylmaleic acid, propylmaleic acid, isopropyl maleic acid, fumaric acid, methylenemalononic acid, glutaconic acid, itaconic acid, methylitaconic acid, mesaconic acid and citraconic acid and their mixtures, as well as the corresponding esters, anhydrides and mixtures of such acids, esters and anhydrides. Isopropyl maleic acid, esters and anhydrides therefore are especially preferred.

Suitable polymers are of the structural formula:



wherein R and R₁ individually represent hydrogen or a C1 to C10 alkyl group, preferably a C1 to C5 alkyl group, most preferably -H or -CH₃, and x generically

represents a number from about 9 to 75; R_4 is a hydrogen or a C_1 - C_3 alkyl group such as i-propyl; and z is between from about 5 to about 20. In a more preferred embodiment, R and R_1 are independently methyl or hydrogen; x is between from about 3 to about 15, and z is about 5 to about 14.

5 A particularly preferred polyolefin is Ceremer® 1608 polyolefin which is the reaction product of $C > 10$ alpha alkenes (i.e., having more than 10 carbon atoms, suitably about 30), maleic anhydride, and mono-isopropyl maleate and exhibits a melting point of 76.7°C (170°F). Additional information on this material can be found at the following website:

10 **Ceremer 1608:**http://www.bakerhughes.com/bakerpetrolite/polymers/olefin_maleic_polymers.htm

CERAMER® 1608 is characterized by a molecular weight (gel permeation chromatography) of about 700, an acid number (BWM 3.01A) of 160, a saponification number (BWM 3.01A) of 212 and a penetration index at 25° C (ASTM 15 1321) of 2.0. The molar ratio of α -olefin:isopropyl maleate in the copolymer is about 1:1. Some units of isopropyl maleate and/or maleic acid anhydride may further be grafted onto the copolymer backbone. Increasing the amount of acid (isopropyl maleate) favors formation of graft copolymers.

The synthetic polymer derived from a polyolefin and an ethylenically 20 unsaturated carboxylic acid or ester or anhydride thereof is blended with at least one other wax. In one embodiment, the ratio of the former wax to the latter wax is 5:1 to 1:10, preferably 2:1 to 1:5.

In general, the at least one other wax may include one or more waxes. Any suitable wax which will form a hydrophobic coating blended with the first wax 25 can be employed. Thus, animal, vegetable, mineral and synthetic waxes may be used as may be mixtures thereof.

Generally speaking, a wax is a substance which is a solid at ambient temperature and which has a low viscosity at just above its melting point. Typically, a wax is a substance having the following properties: (1) crystalline to microcrystalline 30 structure, (2) capacity to acquire gloss when rubbed (as distinct from greases), (3) capacity to produce pastes or gels with suitable solvents or when mixed with other

waxes, (4) low viscosity at just above the melting point. See Grant & Hackh's Chemical Dictionary (5th Edition), page 628, hereby incorporated by reference. Waxes differ from fats in that fats are the esters of the trihydric, lower alcohols.

The following are illustrative types of waxes which may be employed:

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Source	Examples	Compositions
Mineral Waxes	Paraffin	26-30 Carbon atom molecules of aliphatic hydrocarbons.
	Microcrystalline	41-50 Carbon atom molecules of branched-chain hydrocarbons.
	Oxidized microcrystalline	Hydrocarbons, esters, fatty acids.
	Montan	Wax acids, alcohols, esters, ketones.
	Hoechst	Acids, esters (obtained by oxidizing montan wax);
	Ozokerite	High mol. wt. aliphatic and alkenyl hydrocarbons.
Vegetable Waxes	Carnauba	Complex alcohols, hydrocarbons, resins.
	Esparto	Mainly hydrocarbons.
	Flax	Fatty acid esters, hydrocarbons.
	Sugarcane wax	Hydrocarbons, aldehydes, esters, alcohols.
	Candelilla	Hydrocarbons, acids, esters, alcohols, resins.
Animal Waxes	Beeswax	Hydrocarbons, acids, esters, alcohols, lactones.

Synthetic Waxes	Fischer-Tropsch, Polyolefins	Saturated and unsaturated hydrocarbons, oxygen-containing hydrocarbons.
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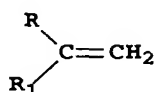
One preferred wax is the fully saturated homopolymers of polyethylene, or copolymers of various alkene monomers, forming polymers with a molecular weight at or below 3,000, a melting point below 130°C, and low melt viscosities. Applicable
5 waxes could include "POLYWAX" available from Petrolite Corp. (St. Louis, Mo.)

POLYWAX® is a linear polyethylene wax. A particularly preferred wax is X-2071® (a.k.a. Polywax® 400), CAS # 9002-88-4, described as polyethylene homopolymer with weight average molecular weight of about 400 and a melting point of 79.5°C (175.1°F). Additional information on this material can be found at the

10 following website: **Polywax 400: http://www.bakerhughes.com/bakerpetrolite/polymers/ethylene_homopolymers.htm**

Another preferred wax includes branched olefins. In one embodiment, the branched hydrocarbon typically has a number average molecular weight (as measured by vapor pressure osmometry) of at least about 300, preferably at least about
15 400, and more preferably at least about 500, and typically has a number average molecular weight of no more than about 10,000, preferably no more than about 5,000, and more preferably no more than about 3,000, although the molecular weight can be outside of these ranges. The branched hydrocarbon typically has a melting point (for crystalline materials) or a softening point (for amorphous or semicrystalline materials)
20 of at least about 30°C, preferably at least about 35°C, and more preferably at least about 50°C, and typically has a melting point or softening point of no more than about 120°C, preferably no more than about 110°C, and more preferably no more than about 100°C, although the melting point can be outside of these ranges. The degree of branching (or average number of branches per molecule) in the branched hydrocarbon
25 typically is at least about 4, and preferably at least about 5, and typically is no more than about 15, and preferably no more than about 10, although the degree of branching can be outside of these ranges. The hydrocarbon can be saturated or unsaturated, and can include cyclic moieties. In addition, oxidized hydrocarbons, such as polyethylene-

based oxidized materials and microcrystalline-based oxidized materials can be used, as can unsaturated and branched hydrocarbon-like molecules using as a core cyclic compounds or dendrimer or arborols. Also suitable are homopolymers and copolymers prepared from monomers of the formula $RCH=CH_2$ wherein R is an alkyl group, typically with from about 1 to about 18 carbon atoms, and preferably with from about 3 to about 12 carbon atoms, although the number of carbon atoms can be outside of these ranges. The polymerized alpha-olefin used in this invention is also known as an olefin derived hydrocarbon polymer or catalytically polymerized alpha-olefin. The polymerized alpha-olefins are prepared from alpha-olefins having the formula:



where R is C_6 to C_{50} alkyl, preferably C_{18} - C_{40} alkyl and R^1 is hydrogen or C_6 to C_{50} alkyl, preferably hydrogen. The polymerization process is described in U.S. Pat. No. 4,060,569 which is incorporated herein by reference. The alpha-olefin is polymerized in the presence of a free radical catalyst. The nature of the free radical catalyst is not critical. Typical free radical catalysts include peroxides and hydroperoxides. The molar ratio of free radical catalyst to alpha-olefin is from about 0.005 to 0.35. A convenient measure of the effective presence of a free radical catalyst is its half-life which is employed as a measure of reaction time based on the number of half-lives. In general, reaction times of from about 1 to 20 half-lives are suitable. The polymerization is carried out at low pressures. The only pressure needed is that necessary to prevent vaporization of the free radical or alpha-olefin. Such pressures are typically less than about 500 psig. The polymerization temperature is typically set such that the free radical catalyst would have a half-life between 0.5 and 3 hours. This in turn is a function of the temperature at which the free radical catalyst decomposes. For peroxides and hydroperoxides, such temperatures are generally in a range from about 40°C to 250°C . The reaction temperature employed will depend on the decomposition temperature of the particular peroxide or hydroperoxide used as catalyst.

The polymerized alpha-olefins are characterized in that they have higher viscosities and greater hardness but lower melting and congealing points than the alpha-olefins from which they are derived. This is in contrast to typical hydrocarbon polymers which have higher viscosities and greater hardness but also higher melting and congealing points than the hydrocarbon monomers from which they are derived. Because of their relatively low molecular weights, the polymerized alpha-olefins are also known as polymeric waxes or polymerized alpha-olefin waxes.

The polymerized alpha-olefins are commercially available. Suitable polymerized alpha-olefins are available from the Bareco Division of Petrolite Corporation under the registered trademark VYBAR, which is available in solid (e.g. VYBAR 103, VYBAR 260) or liquid (e.g. VYBAR 825) form. (VYBAR is a trademark of Petrolite Corporation.) The use of the polymerized alpha-olefin in solid rather than liquid form is preferred.

VYBAR® is a polymerized α -olefin prepared by polymerizing α -olefins under free radical conditions at low pressures. The polymers are unique in that although α -olefin polymers generally have higher molecular weight, greater viscosity and greater hardness than the starting monomer, VYBAR polymers generally have lower melting points and congealing points than the starting monomer. The monomers employed are primarily alpha-olefins of the formula $RCH=CH_2$ where R is an alkyl group having about 4 to 50 carbon atoms or is a mixture of alpha-olefins, vinylidene compounds, internal olefins and saturated hydrocarbons. Because alpha-olefins are primarily employed, this term is often used to indicate both alpha-olefins and mixtures of various combinations of alpha-olefins, vinylidenes, internal olefins and saturates.

Examples of suitable branched hydrocarbons include VYBAR® 253 available from Baker Petrolite Corp., an alpha-olefin with a number average molecular weight of about 520, a softening point of about 67°C (measured by ASTM method D36) and a degree of branching of from about 5 to about 10. This material is a polymer based on an ethylene structure having pendant hydrocarbon side chains, also referred to as a poly- α -olefin or a poly-1-alkene. Also suitable are VYBAR® 103, with a number average molecular weight of 2,800, VYBAR® 260, with a number average molecular weight of 2,600, and the VYBAR® X-series polymers, such as X-

6044, X-6059, X-6028, and the like. Also suitable are oxidized hydrocarbons such as those available from Petrolite as polyethylene-based oxidized materials and microcrystalline-based oxidized materials, such as the CARDIS® and PETRONAUBA® materials.

5 A particularly preferred branched polyolefin is X-6031® (a.k.a. Vybar® 103), CAS #68527-08-2, described as alkenes, macromonomers with C>10 (greater than 10 carbon atoms) alpha-polymerized with a softening point of 74°C (165.2°F). Additional information on this material can be found at the following website:

Vybar 103: <http://www.bakerhughes.com/>

10 **[bakerpetrolite/polymers/vybar/index.htm](http://www.bakerhughes.com/bakerpetrolite/polymers/vybar/index.htm)**

The wax mixture defined above can be employed in the invention herein at any concentration useful for the intended purpose. In general, good results have been obtained at a concentration of about 0.02 to about 0.12 g/m², preferably about 0.03 to about 0.09 g/m², with or without a binder.

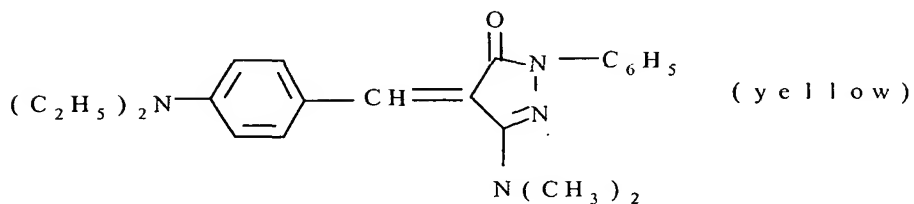
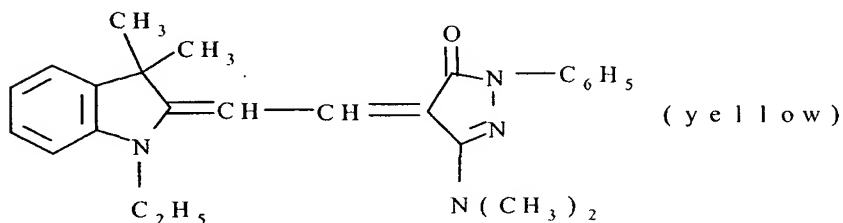
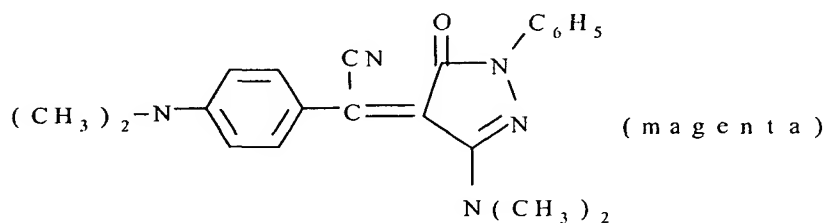
15 Any binder may also be used in the slipping layer of the invention provided it will be useful for the intended effect. In a preferred embodiment, polymeric thermoplastic binders are employed. Examples of such materials include, for example, Poly(styrene-coacrylonitrile) (70/30 wt. ratio); poly(vinyl alcohol-co-butyral) (available commercially as Butvar 76.RTM. by Monsanto Corp.); poly(vinyl 20 alcohol-co-acetal); poly(vinyl alcohol-co-benzal); polystyrene; poly(vinyl acetate); cellulose acetate butyrate; cellulose acetate propionate; cellulose acetate; ethyl cellulose; cellulose triacetate; poly(methylmethacrylate); copolymers of methyl methacrylate; etc. In another preferred embodiment of the invention, the thermoplastic binder is cellulose acetate propionate or polyvinyl acetal.

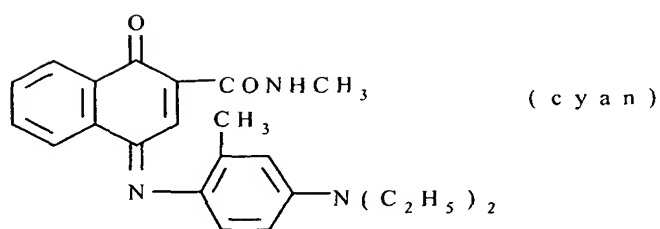
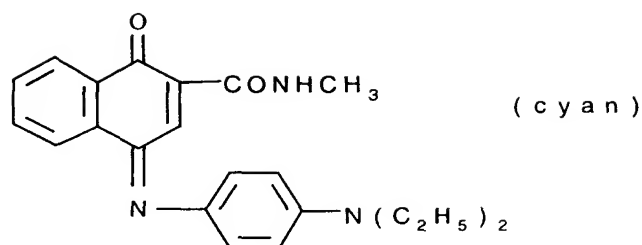
25 The amount of the optional binder employed in the slipping layer of the invention is not critical. In general, the binder may be employed in an amount of from about 0.1 to about 2 g/m².

Any dye can be used in the dye layer of the dye-donor element of the invention provided it is transferable to the dye-receiving layer by the action of heat.

30 Especially good results have been obtained with sublimable dyes. Examples of sublimable dyes include anthraquinone dyes, e.g., Sumikalon Violet RS® (Sumitomo

- Chemical Co., Ltd.), Dianix Fast Violet 3R FS® (Mitsubishi Chemical Industries, Ltd.), and Kayalon Polyol Brilliant Blue N BGM® and KST Black 146® (Nippon Kayaku Co., Ltd.); azo dyes such as Kayalon Polyol Brilliant Blue BM®, Kayalon Polyol Dark Blue 2BM®, and KST Black KR® (Nippon Kayaku Co., Ltd.),
- 5 Sumickaron Diazo Black 5G® (Sumitomo Chemical Co., Ltd.), and Miktazol Black 5GH® (Mitsui Toatsu Chemicals, Inc.); direct dyes such as Direct Dark Green B® (Mitsubishi Chemical Industries, Ltd.) and Direct Brown M® and Direct Fast Black D® (Nippon Kayaku Co. Ltd.); acid dyes such as Kayanol Milling Cyanine 5R® (Nippon Kayaku Co. Ltd.); basic dyes such as Sumicacryl Blue 6G® (Sumitomo
- 10 Chemical Co., Ltd.), and Aizen Malachite Green® (Hodogaya Chemical Co., Ltd.):





or any of the dyes disclosed in U.S. Patent 4,541,830, the disclosure of which is hereby
 5 incorporated by reference. The above dyes may be employed singly or in combination
 to obtain a monochrome. The dyes may be used at a coverage of from about 0.05 to
 about 1 g/m² and are preferably hydrophobic.

A dye-barrier layer may be employed in the dye-donor elements of the
 invention to improve the density of the transferred dye. Such dye-barrier layer
 10 materials include hydrophilic materials such as those described and claimed in U.S.
 Patent No. 4,716,144 by Vanier, Lum and Bowman.

The dye layer of the dye-donor element may be coated on the support or
 printed thereon by a printing technique such as a gravure process.

Any material can be used as the support for the dye-donor element of
 15 the invention provided it is dimensionally stable and can withstand the heat of the
 thermal printing heads. Such materials include polyesters such as poly(ethylene
 terephthalate); polyamides; polycarbonates; glassine paper; condenser paper; cellulose
 esters such as cellulose acetate; fluorine polymers such as polyvinylidene fluoride or
 poly(tetrafluoroethylene-co-hexafluoropropylene); polyethers such as
 20 polyoxymethylene; polyacetals; polyolefins such as polystyrene, polyethylene,
 polypropylene or methylpentane polymers; and polyimides such as polyimide amides
 and polyetherimides. The support generally has a thickness of from about 2 to about

30 micrometers. It may also be coated with a subbing layer, if desired, such as those materials described in U.S. Patent No. 4,695,288 or U.S. Patent No. 4,737,486.

The dye-receiving element that is used with the dye-donor element of the invention usually comprises a support having thereon a dye image receiving layer.

5 The support may be a transparent film such as a poly(ether sulfone), a polyimide, a cellulose ester such as cellulose acetate, a poly(vinyl alcohol-co-acetal) or a poly(ethylene terephthalate). The support for the dye-receiving element may also be reflective such as baryta-coated paper, polyethylene-coated paper, white polyester (polyester with white pigment incorporated therein), an ivory paper, a condenser paper
10 or a synthetic paper such as DuPont Tyvek®.

The dye image-receiving layer may comprise, for example, a polycarbonate, a polyurethane, a polyester, polyvinyl chloride, poly(styrene-co-acrylonitrile), poly(caprolactone) or mixtures thereof. The dye image-receiving layer may be present in any amount which is effective for the intended purpose. In general,
15 good results have been obtained at a concentration of from about 1 to about 5 g/m².

The support for the image receiving layer may be transparent or reflective, and may comprise a polymeric, a synthetic paper, or a cellulosic paper support, or laminates thereof. Examples of transparent supports include films of poly(ether sulfones), polyimides, cellulose esters such as cellulose acetate, poly(vinyl
20 alcohol-co-acetals), and poly(ethylene terephthalate). The support may be employed at any desired thickness, usually from about 10 µm to 1000 µm. Additional polymeric layers may be present between the support and the dye image-receiving layer. For example, there may be employed a polyolefin such as polyethylene or polypropylene. White pigments such as titanium dioxide, zinc oxide, etc., may be added to the
25 polymeric layer to provide reflectivity. In addition, a subbing layer may be used over this polymeric layer in order to improve adhesion to the dye image-receiving layer. Such subbing layers are disclosed in U.S. Patent Nos. 4,748,150, 4,965,238, 4,965,239, and 4,965,241, the disclosures of which are incorporated by reference. The receiver element may also include a backing layer such as those disclosed in U.S. Pat. Nos.
30 5,011,814 and 5,096,875, the disclosures of which are incorporated by reference. Supports for the dye receiving layer are, for example, disclosed in commonly assigned

US Patents Nos. 5,244,861, EP0671281, and US Patent No. 5,928,990, which are hereby incorporated by reference in their entirety.

5 The composition, for use in an image-receiving layer, may also contain a release agent, such as a silicone or fluorine based compound, as is conventional in the art. Resistance to sticking during thermal printing may be enhanced by the addition of such release agents to the dye-receiving layer or to an overcoat layer. Various releasing agents are disclosed, for example, in US Patent No. 4,820,687 and US Patent No. 4,695,286, the disclosures of which are hereby incorporated by reference in their entirety.

10 As noted above, the dye donor elements of the invention are used to form a dye transfer image. Such a process comprises imagewise heating a dye-donor element as described above and transferring a dye image to a dye receiving element to form the dye transfer image.

The dye donor element of the invention may be used in sheet form or in a continuous roll or ribbon. If a continuous roll or ribbon is employed, it may have only one dye or may have alternating areas of other different dyes, such as sublimable cyan and/or magenta and/or yellow and/or black or other dyes. Such dyes are disclosed in U.S. Patent Nos. 4,541,830; 4,698,651; 4,695,287; 4,701,439; 4,757,046; 4,743,582; 4,769,360 and 4,753,922, the disclosures of which are hereby incorporated by reference. Thus, one-, two-, three- or four-color elements (or higher numbers also) are included within the scope of the invention.

20 In a preferred embodiment of the invention, the dye-donor element comprises a poly(ethylene terephthalate) support coated with sequential repeating areas of yellow, cyan and magenta dye, and the above process steps are sequentially performed for each color to obtain a three-color dye transfer image. Of course, when the process is only performed for a single color, then a monochrome dye transfer image is obtained.

Thermal printing heads which can be used to transfer dye from the dye-donor elements of the invention are available commercially. There can be employed, for example, a Fujitsu Thermal Head (FTP-040 MCSOO1), a TDK Thermal Head F415 HH7-1089 or a Rohm Thermal Head KE 2008-F3.

A thermal dye transfer assemblage of the invention comprises

- (a) a dye-donor element as described above, and
- (b) a dye-receiving element as described above,

the dye receiving element being in a superposed relationship with the dye donor element so that the dye layer of the donor element is in contact with the dye image-receiving layer of the receiving element.

The above assemblage comprising these two elements may be preassembled as an integral unit when a monochrome image is to be obtained. This may be done by temporarily adhering the two elements together at their margins. After transfer, the dye-receiving element is then peeled apart to reveal the dye transfer image.

When a three-color image is to be obtained, the above assemblage is formed on three occasions during the time when heat is applied by the thermal printing head. After the first dye is transferred, the elements are peeled apart. A second dye-donor element (or another area of the donor element with a different dye area) is then brought in register with the dye-receiving element and the process is repeated. The third color is obtained in the same manner.

The following examples are provided to illustrate the invention.

EXAMPLE 1

This example shows the propensity to have one-time (1X) retransfer of the dye to the slip layer when the donor spool is coated. Since the dye-donor element is a roll-format product, the slip layer and dye layer will be in direct contact when the material is coated on a large roll. The "retransfer" of interest is from the dye side to the slip layer side, because when the large-manufacture roll is further divided into smaller rolls, the dye that originally transferred to the slip side of the coating can retransfer back to the dye side, but in a different place on the dye coating, thereby contaminating it with unwanted dye. For example, in the large-manufacture roll, magenta can retransfer to the slip side, and then upon the making of smaller rolls from this larger roll, the magenta dye can retransfer from the slip side to the yellow patch, for example, resulting in contamination of the yellow dye patch with magenta dye. The result can be defective color produced during dye-transfer printing caused by unwanted dye mixed with the desired dye.

A dye donor element was prepared by coating the following layers in the order recited on 4.5 micron poly(ethylene terephthalate) support:

- (1) a subbing layer of a titanium alkoxide (DuPont Tyzor TBT®) (0.12 g/m^2) from n-propyl acetate and n-butyl alcohol solvent mixture, and
- 5 (2) a dye layer containing repeating alternating areas of the cyan dye illustrated above (0.37 g/m^2), the magenta dye illustrated above (0.28 g/m^2) and the yellow dye illustrated above (0.15 g/m^2) in a cellulose acetate propionate binder (0.27 g/m^2) coated from toluene, methanol and cyclopentanone solvent mixture.

A dye donor slipping layer side was prepared by coating the following layers in the order recited on 4.5 micron poly(ethylene terephthalate) support :

- (1) a subbing layer of a titanium alkoxide (DuPont Tyzor TBT®) (0.12 g/m^2) from n-propyl acetate and n-butyl alcohol solvent mixture, and
- (2) a slipping layer of polymers listed below in a polyvinyl acetal binder (0.4 g/m^2) coated out of an appropriate solvent as illustrated in Table 1, being either (A)
- 15 diethyl ketone and methanol or (B) toluene, methanol and cyclopentanone.

The slipping-layer polymers used tested were:

Control polymers ("CP"):

CP1: DBE-224®, dimethylsiloxane-ethylene oxide block copolymer, from
20 Gelest (Tullytown, PA).

CP2: Silwet L-7230®, polydimethylsiloxane-co-methyl(3-hydroxypropyl) siloxane graft with poly(ethylene/propylene glycol), from Crompton Corporation (Friendly, WV).

CP3: APS-241®, methylstyryl modified silicone fluid, from Advanced Polymer
25 Inc. (Carlstadt, NJ).

CP4: APS-222®, reactive organo-modified silicone fluid, from Advanced Polymer Inc. (Carlstadt, NJ).

CP5: PS-513®, polydimethylsiloxane, from United Chemical Technologies (Briston, PA).

30 CP6: Candelilla Wax Slurry, from Eastman Kodak Company (Rochester, NY).

Invention polymers ("IP"):

IP1: Polywax 400®, ethene homopolymer, from Baker-Petrolite Polymers (Sugar Land, TX).

5 IP2: Vybar 103®, polyalphaolefin, from Baker-Petrolite Polymers (Sugar Land, TX).

IP3: Ceremer 1608®, reaction products of maleic anhydride and mono-isopropyl maleate, from Baker-Petrolite Polymers (Sugar Land, TX).

The IX retransfer associated with the various slip layers was tested by making separate coatings of slip and dye in which the opposite side was bare PET support without any coating. The samples were placed so that the slip side sample and the dye side sample were facing each other. These samples were then mounted in a screw press at approximately 300 psi for seven days at room temperature. Samples were interleaved with receiver to provide uniform pressure. Samples were removed from the fixture and placed against a sheet of thermal receiver. The L*a*b* values were read using a Byk-Gardner unit with an integrating sphere. The a*b* vector length refers to the length of the vector along the axis in CIELAB 3-dimensional color space. The results of the tests are shown below, in which the vector length, which is proportional to the magnitude of the color shift, is given in the Table 1 below.

20

TABLE 1

SLIP LAYER	SOLVENT	a*b* VECTOR LENGTH
CP5 (0.01 g/m ²) + CP6 (0.023 g/m ²)	A	1.1
IP1(0.02 g/m ²)+IP2(0.02 g/m ²)+IP3 (0.02 g/m ²)	B	0.4
CP3(0.032 g/m ²) + CP4 (0.032 g/m ²)	B	1.45
CP1(0.032 g/m ²) + CP3 (0.032 g/m ²)	B	3
CP1(0.032 g/m ²) + CP2 (0.032 g/m ²)	B	4.1

The shorter the length of the vector, the better, and the most desirable situation is to have a vector length of 0. The above results indicate that the slipping

layer according to the invention gave superior performance in terms of 1X retransfer as compared to the control materials.

EXAMPLE 2

5 This example shows the superiority of the slip layer according to the present invention in terms of preventing sticking and providing smooth transfer of the dye-donor past the print head. A defect or deficiency in the performance of that layer causes intermittent rather than continuous transport across the thermal head. The dye transferred thus does not appear as a uniform area, but rather as a series of alternating
10 light and dark bands (so-called "chatter marks").

Smooth transfer across a wide range of printing conditions is another desirable performance characteristic for a slipping layer. Variable print forces along either the length or width of a print could cause image defects. Differences in print forces are specially magnified in regions of abrupt temperature change. At the
15 transition from Dmax (maximum print density) to Dmin (minimum print density), the force may spike upward from Dmax to a peak force and then return to Dmin. This differential is referred to as "pops" since an audible popping noise can be heard in extreme cases during printing.

A dye donor element was prepared by coating the following layers in
20 the order recited on 4.5 micron poly(ethylene terephthalate) support:

- (1) a subbing layer of a titanium alkoxide (DuPont Tyzor TBT®) (0.12g/m^2) from n-propyl acetate and n-butyl alcohol solvent mixture, and
- (2) a dye layer containing repeating alternating areas of the cyan dye illustrated above (0.37 g/m^2), the magenta dye illustrated above (0.28 g/m^2) and the yellow dye
25 illustrated above (0.15 g/m^2) in a cellulose acetate propionate binder (0.27 g/m^2) coated from toluene, methanol and cyclopentanone solvent mixture.

A dye donor slipping layer side was prepared by coating the following layers in the order recited on 4.5 micron poly(ethylene terephthalate) support :

- (1) a subbing layer of a titanium alkoxide (DuPont Tyzor TBT®) (0.12g/m^2) from n-
30 propyl acetate and n-butyl alcohol solvent mixture, and

(2) a slipping layer of polymers listed below in a polyvinyl acetal binder (0.4 g/m^2) coated out of an appropriate solvent as illustrated in Table 1, being either (A) diethyl ketone and methanol or (B) toluene, methanol and cyclopentanone.

5 The slipping-layer polymers used in the test were as follows:

Invention polymers (IP):

IP1: Polywax 400®, ethene homopolymer, from Baker-Petrolite Polymers (Sugar Land, TX).

10 IP2: Vybar 103®, polyalphaolefin, from Baker-Petrolite Polymers (Sugar Land, TX).

IP3: Ceremer 1608®, reaction products of maleic anhydride and mono-isopropyl maleate, from Baker-Petrolite Polymers (Sugar Land, TX).

15 The test donor samples with copolymer slipping layers applied as described were subjected to conventional testing for the force needed to transport the donor/receiver combination past a thermal print head as follows:

20 The dye side of the above donor set element strip was placed in contact with the dye-receiving layer of the same area. This assembly was clamped to a stepper motor driving a 60 mm diameter rubber roller. Next, a TDK Model L-231 thermal head, thermostatted at 28°C . was pressed against the slipping layer side of the assembly with a force of 24.75 Newton (5.5 lbs) pushing it against the rubber roller.

25 The imaging electronics were activated causing the donor/receiver assemblage to be drawn between the print head and roller. At the same time the resistive elements in the thermal print head were pulsed for 128 microsec/pulse at 134 microsecond intervals during the 4.575 millisecc/dot printing time. A stepped density image was generated incrementally increasing the number of pulses/dot from 0 to 32 (Dmin to Dmax). The voltage supplied to the print head was approximately 13 volts, resulting in a maximum total energy of approximately 1.45 mJ/dot.

30 The test pattern consisted of a series of bars, first a series of wider bars (and then a series of narrower bars. In particular, a first wide bar at high density (to warm up the printhead) was followed by a second wide bar at low density Dmax,

followed by a third wide bar at high density. This was followed by a wide bar at Dim and then a series of thinner alternating high density and zero density bars.

The Dmid1, Dmid2 and Dmid3 parameters were taken from friction readings of the second first cyan bar, respectively near the beginning, middle, and end of the bar. The Dmax1 and Dmax2 were taken from the third bar, near the beginning and end thereof. The Dmin reading was taken from the area of no printing after the third cyan bar. The “Pops” reading were taken from eight successive areas of printing/not printing which simulates D-max, then D-min printing. According to the test, low friction numbers are desired, and also similar friction numbers between the hot and cold areas.

As each area test pattern of given density was being generated, the torque required to draw the assemblage through the print nip was measured with a Himmelstein Corp. Model 3-308TL (16-1) Torquenter (1.09 meter-Newton range) and Model 6,201 Conditioning Module. Print forces below 10 newton are generally acceptable. Data were taken at 0 pulses/dot (DMIN), 8 pulses/dot (DMID), and at 32 pulses/dot (DMAX).

Table 2 below shows the friction gauge testing results for various polymer combinations:

TABLE 2

Description	Laydown (g/m ²)			Dmin	Dmid2	Dmid1	Dmid3	Dmax1	Dmax2	POP
	IP3	IP2	IP1							
IP3	0.06			1.89	4.23	4.21	4.08	6.51	6.6	8.35
IP2		0.06		3.48	2.74	2.74	2.62	2	1.91	2.11
IP1			0.06	2.08	2.81	3.19	2.21	5.08	4.06	18.63
IP3 + IP2	0.03	0.03		2.73	2.5	2.51	2.4	2	1.89	1.98
IP1 + IP3	0.03		0.03	1.71	2.1	2.1	1.99	1.46	1.39	1.9
IP2 + IP1		0.03	0.03	2.31	2.79	2.79	2.64	2.78	2.53	2.08
IP1 + IP2 + IP3	0.02	0.02	0.02	1.82	1.95	1.97	1.85	1.39	1.31	1.31

The above results indicate that the slipping layer according to the invention gave superior performance as compared to the control materials. The data below illustrate the synergistic effect of the two polymers IP3 and IP2. In the data of
5 Table 2, the lower the numerical value, the better the performance of the slipping layer, the units being in pounds.

The invention has been described in detail with particular reference to preferred embodiments thereof, but it will be understood that variations and modifications can be effected within the spirit and scope of the invention.